

Work Order ID 160951

Friday, May 05, 2017 10:23:00 AM

160951

Page 1

Item ID: D4950-3 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Mount
 Start Date: 5/15/2017 Start Qty: 4.00 ***4*** Cust Item ID:
 Required Date: 5/18/2017 Req'd Qty: 4.00 ***4*** Customer:
 Reference: SCHEDULED/C

Approvals: Process Plan:  Date: MAY 05 2017 Tooling: _____ Date: _____
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____
 Run Start ***NR1***
 Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4950	B								

100 FLOW WATER JET 0.00
100
 Waterjet Memo 0.38
 FLOW CNC Waterjet 1-Cut as per Dwg D4950
 Dwg Rev: B
 Prog Rev: B
 2-Deburr if necessary

 Set for 17/05/11

110 QC2- Inspect parts off machine FAI/FAIB 0.00
110
 QC Memo 0.00
 Quality Control

 Set for 17/05/11

120 QC8- Inspect parts - second check 0.00
120
 QC Memo 0.00
 Quality Control

4  
 MAY 11 2017

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[illegible]

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17/5/15 

 MAY 15 2017

Picklist Print

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Page 1

Work Order ID: 160951

160951

Parent Item: D4950-3

D4950-3

Parent Item Name: Mount

Start Date: 5/15/2017

Required Date: 5/18/2017

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP REV:A 13.09.24 NEW ISSUE DD VERF:JLM IPP
REV:B 13.12.23 DWG REV.PB2 DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M17-4-S-11GA		Purchased		No		100	sf	17.0000	0.125	0.526316			

M17-4-S-11GA

S/S sheet 0.125 (AMS5604)

05/17/11

Location

Loc Qty

Loc Code

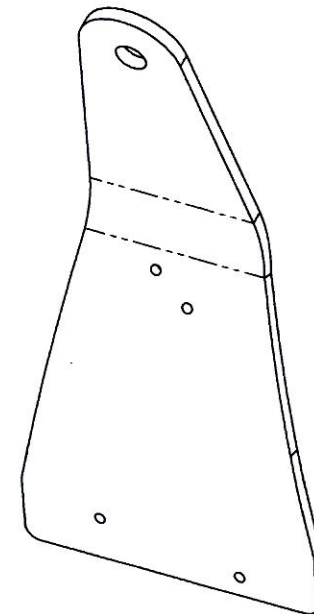
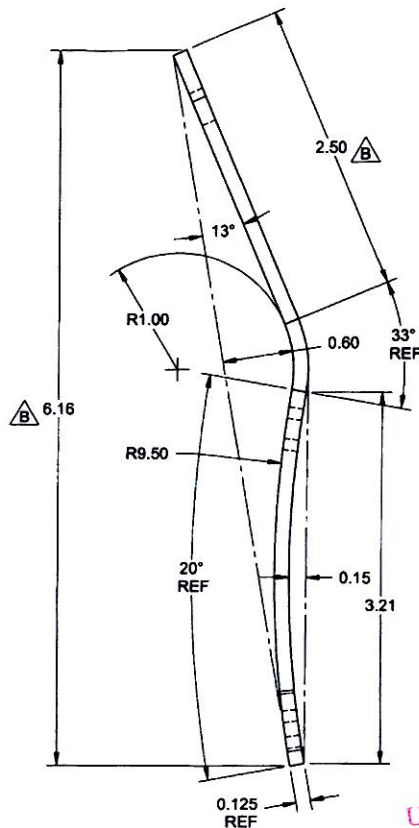
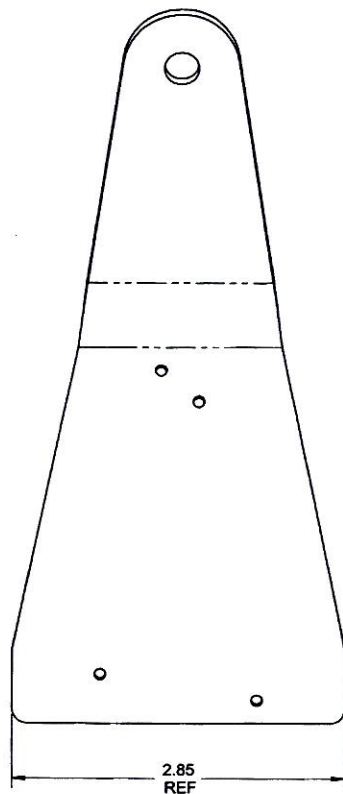
MAT019

17

m127802

17

0.62



D4950-3 MOUNT

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 160957 115
170511

RECEIVED
2014-01-15

- NOTES:
1) MATERIAL: MAKE FROM D4950-3F
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 0.42 lbs

APPROVED

DESIGN	DB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	MB		
CHECKED	AP	DRAWING NO.	REV. B
MFG. APPR.	DD	D4950	SHEET 5 OF 6
APPROVED	MP	TITLE	SCALE
DE APPR.	DS	MOUNT	NTS
DATE	14.01.09	COPYRIGHT © 2013 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

DQA: _____ Date: _____

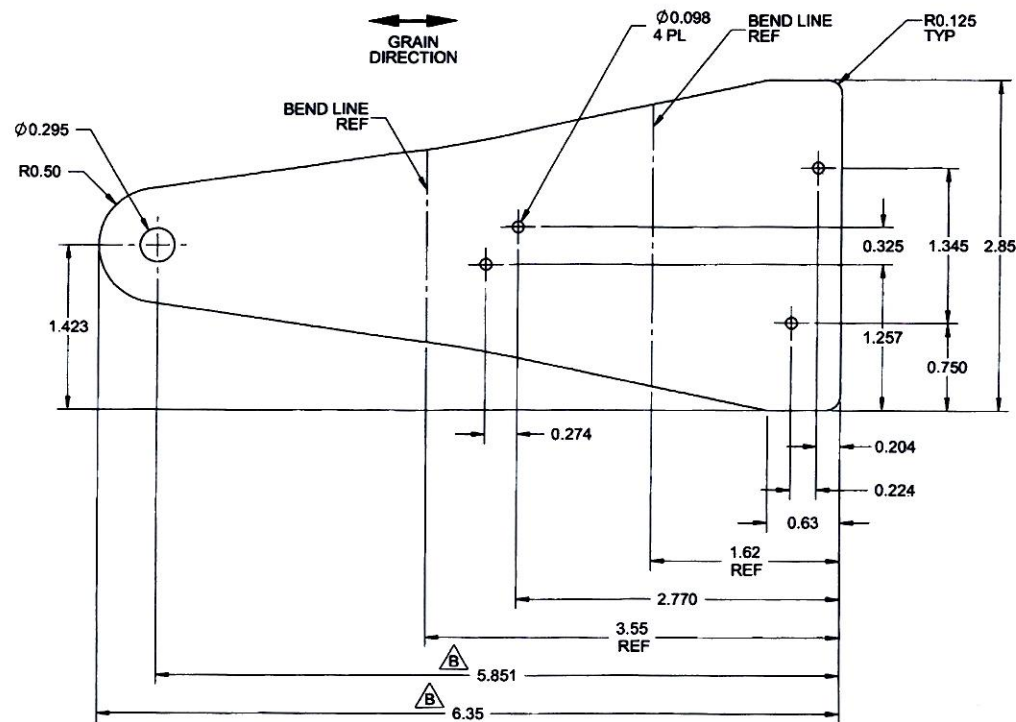


WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐								
Misidentified ☐	Past Due ☐	OTHER : ☐							



D4950-3F FLAT PATTERN

NOTES:

- 1) MATERIAL: 17-4PH STAINLESS STEEL SHEET, 11 GA (0.125 THICK), PER AMS 5604 $\triangle$ B
MIN YIELD STRENGTH = 105 KSI
MIN ULTIMATE STRENGTH = 135 KSI
REF DART SPEC M17-4-S11GA
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.42 lbs

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